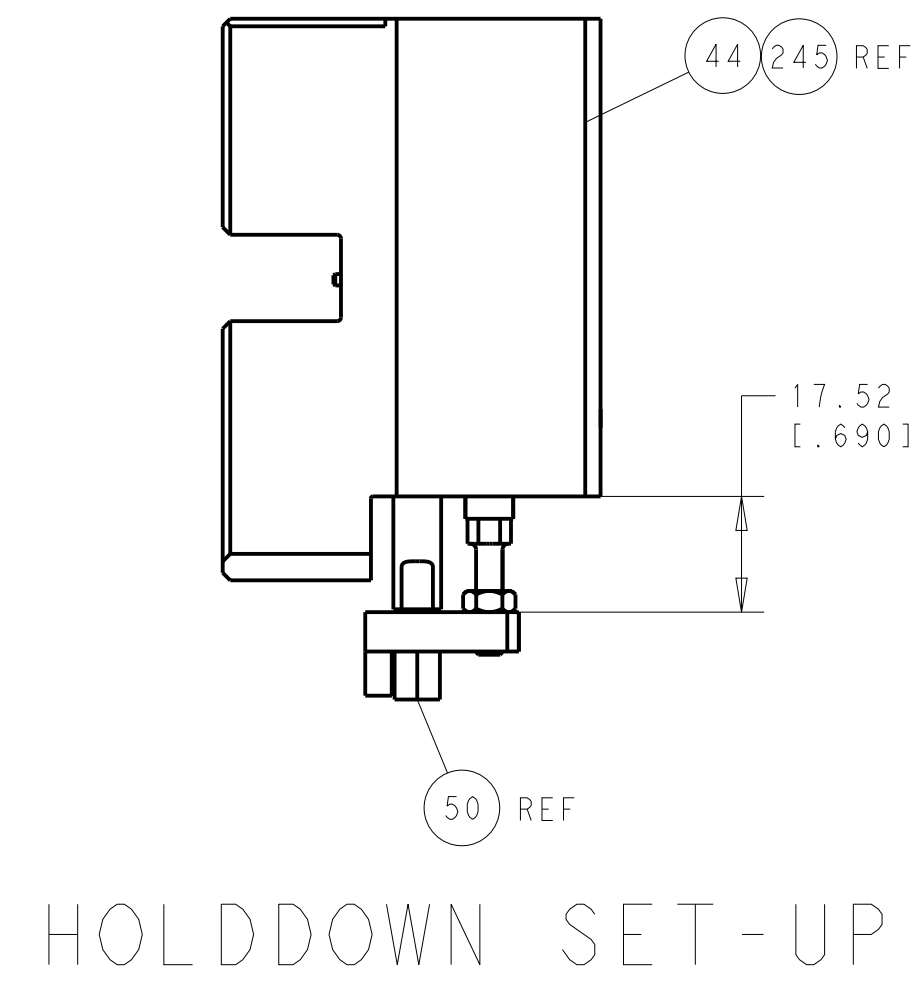
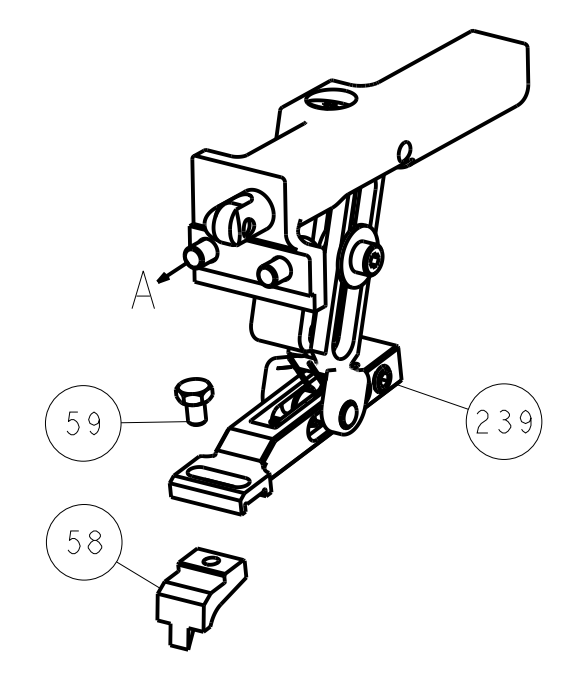


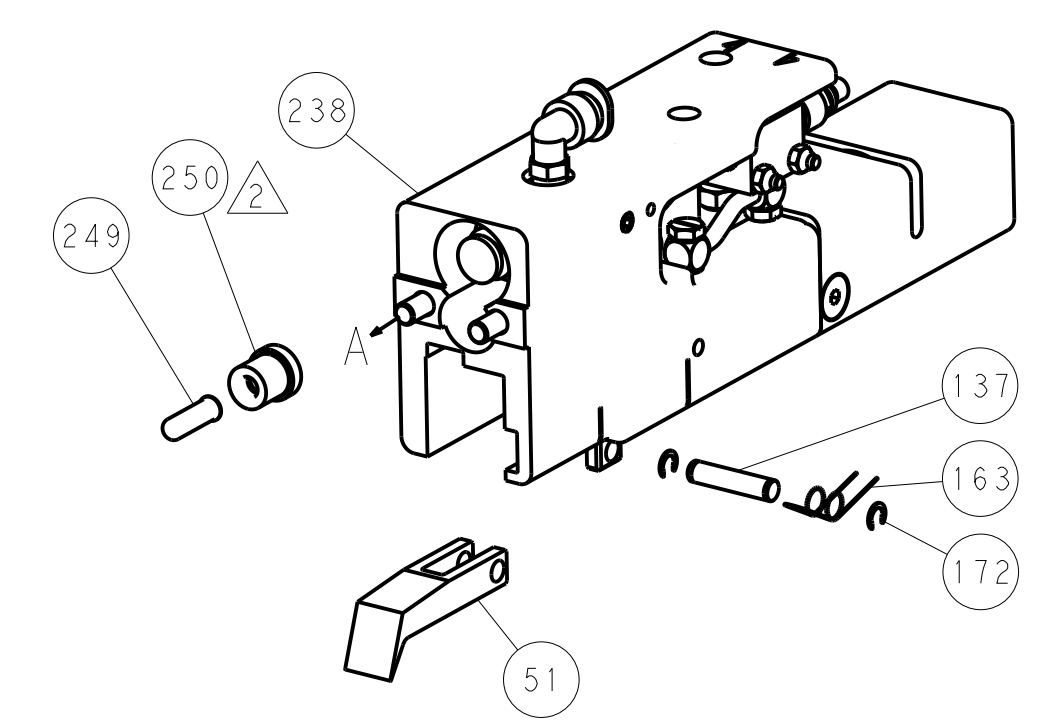
LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



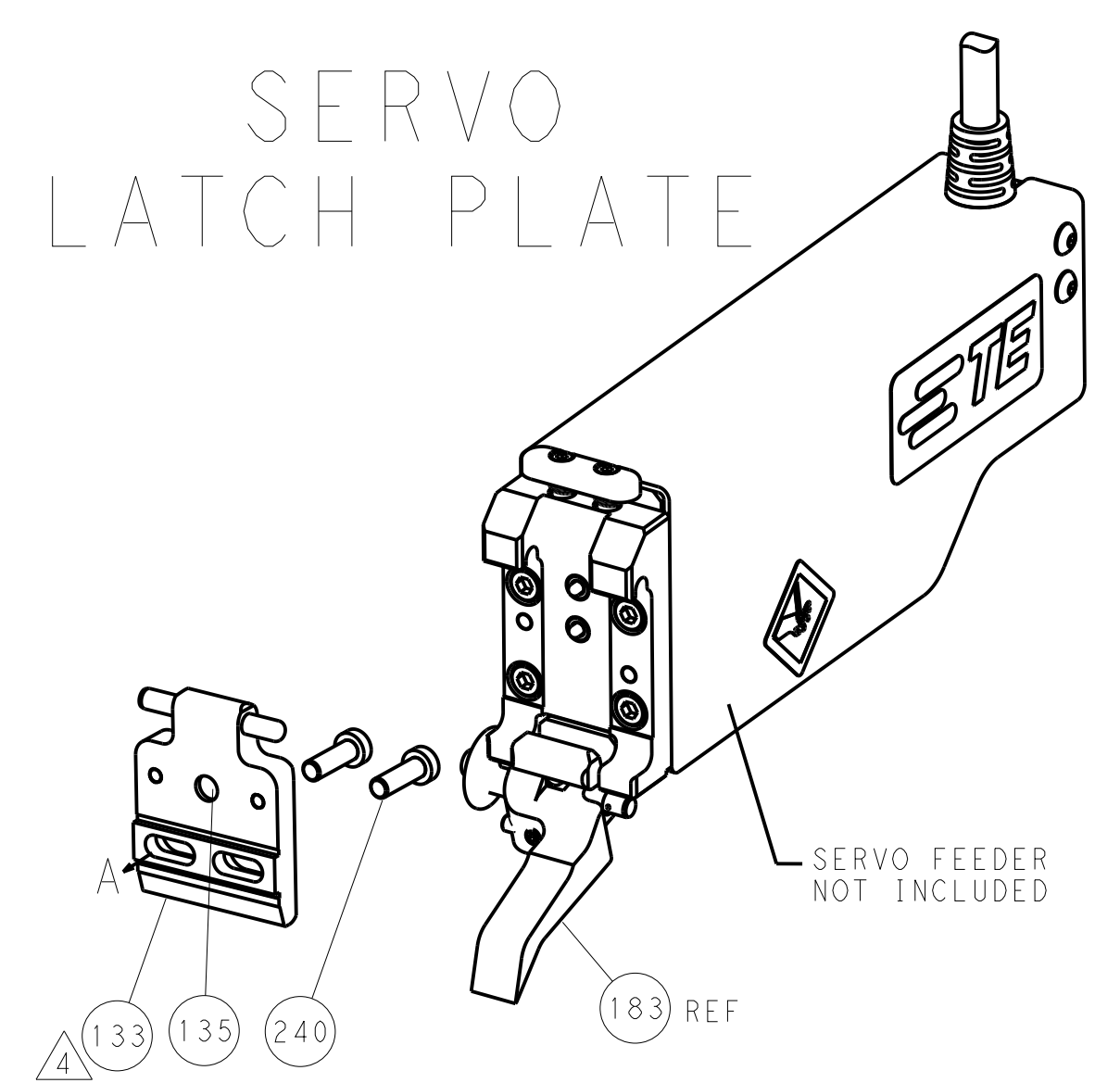
FEED TYPE
MECHANICAL



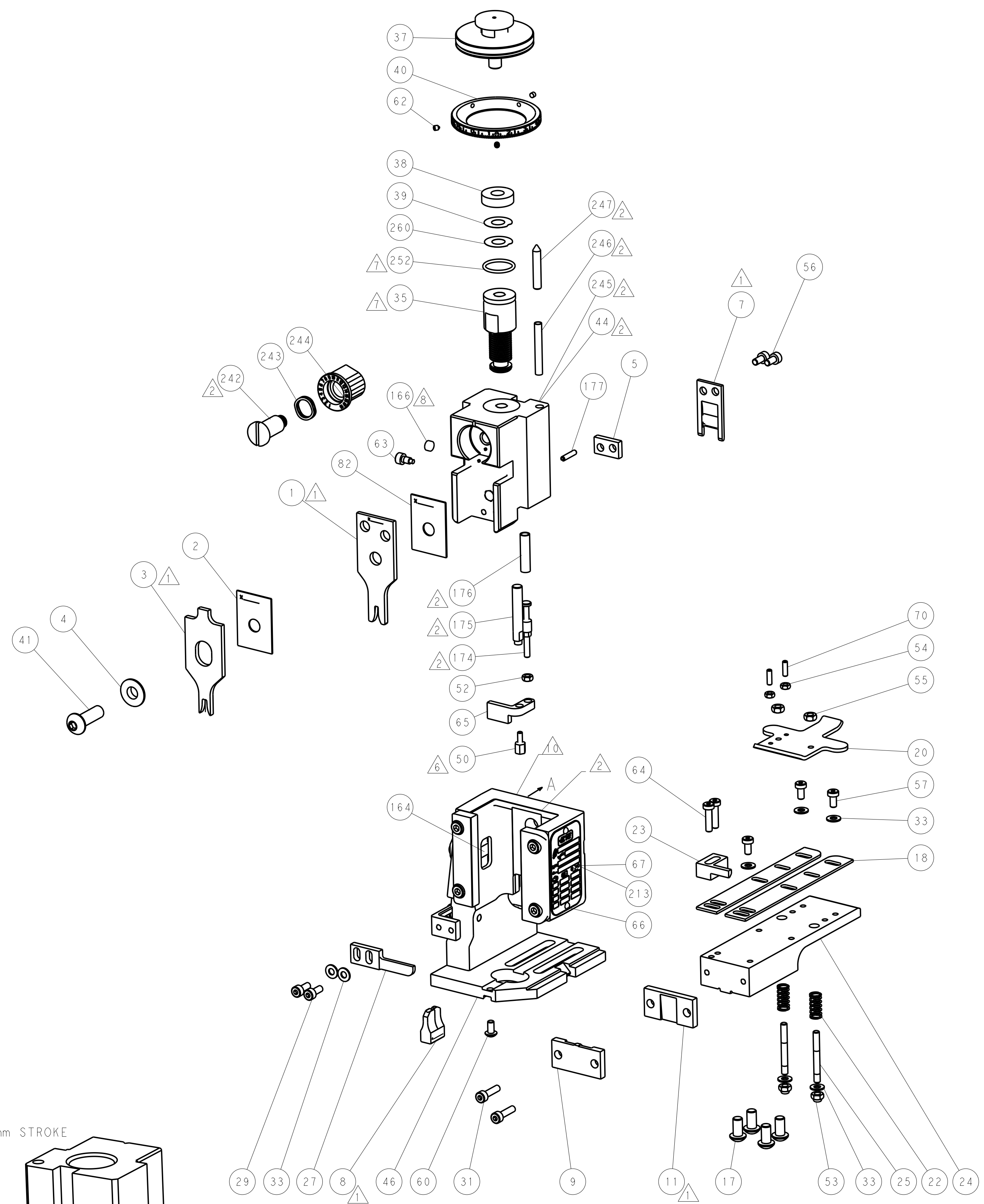
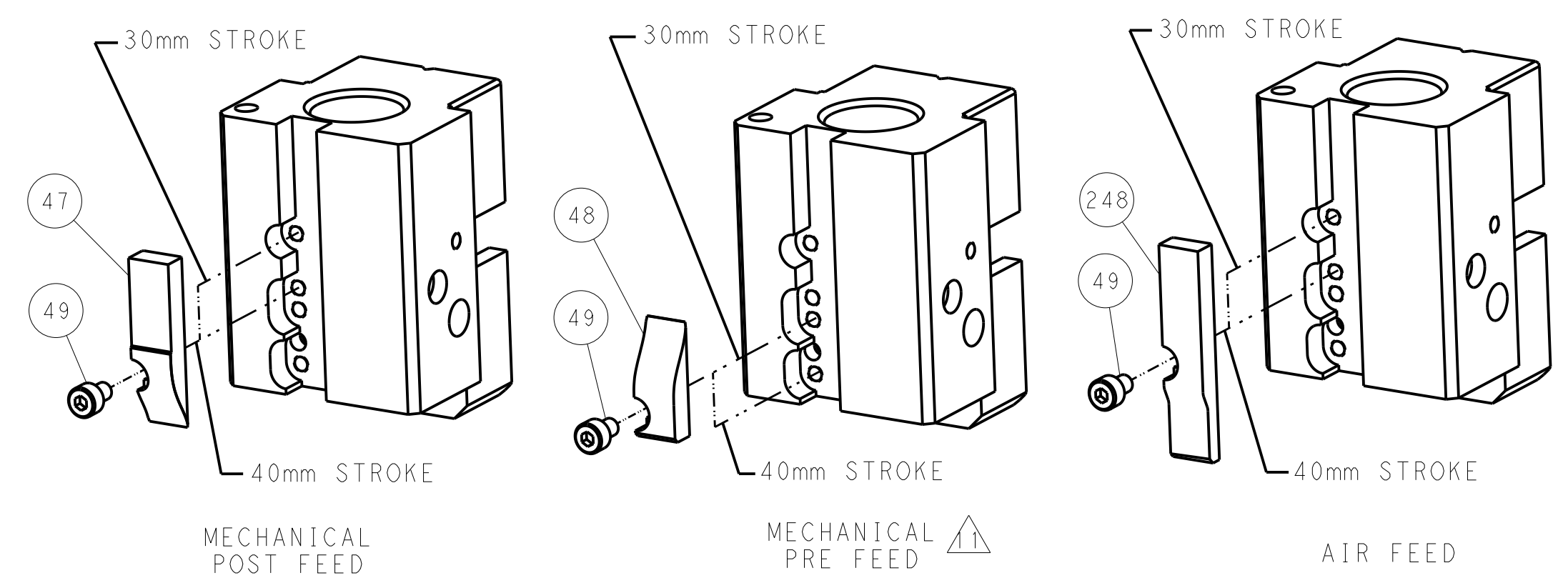
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS



ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.5		FINISH	
MATERIAL		DWN		REV	
		C.K. CHEN		10MAY2012	
		S.X.I		10MAY2012	
		I. CRUZ		10MAY2012	
		PRODUCT SPEC		NAME	
		APPLICATION SPEC		SIZE	
		WEIGHT		CAGE CODE	
		Customer Accessible Production Drawing		DRAWING NO	
		SCALE		SHEET	
		1:1		2 of 4	
				REV	
				A1	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2150258-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-2	-	2063440-1
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150258-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150258-4	-	-	-
	2-2150258-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901697-1	8-2150258-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150258-4	-	-	-
	2-2150258-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
	2-2150258-7	A	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	2119792-1	-	2119641-2	-	2063440-1
	7-2150258-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.56 mm [.140]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE FASTON .205 SERIES			
WIRE STRIP LENGTH 4.39-5.16 mm [.173-.203 IN]		INSULATION DIAMETER RANGE Ø2.16-3.18 mm [.085-.125 IN]	
TERMINAL APPLICATION SPECIFICATION		-	
114-2036		-	
-		-	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
42710-1	42710-2	42198-1	42198-2
42299-2	60904-2		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
18 AWG		1.22+/-0.05 [.048+/- .002]		5.4
20 AWG		1.12+/-0.05 [.044+/- .002]		6.4
22 AWG		1.07+/-0.05 [.042+/- .002]		6.9



- ⚠

RECOMMENDED SPARE PARTS
- ⚠

GREASE BEARING SURFACES LIGHTLY
3.

LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- ⚠

APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150258-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150258-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150258-5
5.

ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- ⚠

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50, 62 & 242.
- ⚠

GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- ⚠

MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- ⚠

CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- ⚠

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- ⚠

THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.

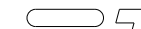
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-77-27-25-22-21					PART NO	DESCRIPTION	ITEM NO

PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

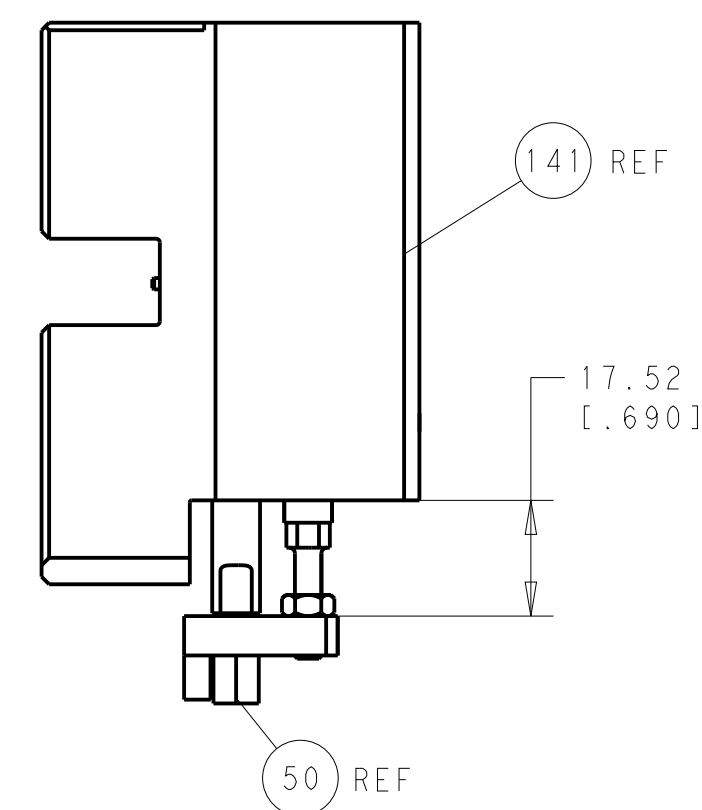
2			1							
SET UP GAUGE 2119599-2			LOC A	DIST 66	REVISIONS					
			P	LTR	DESCRIPTION			DATE	DWN	APVD
				-	SEE SHEET 1			-	-	-

-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	-	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	1	-	-	2119740-2	TAG,IDENTIFICATION	213
-	4	4	4	4	2079383-9	SCR, BHSC, RoHS (M6 X 20)	186
-	-	REF	-	-	1901697-1	FEED FINGER ASSEMBLY,EF	183
-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	153
-	-	-	1	-	2119641-2	FEED CAM, AIR FEED	152
-	1	1	1	1	2119798-2	DETENT PIN	145
-	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF	141
-	1	1	1	1	2119651-1	RAM, ASIAN STYLE, END FEED	140
-	1	1	1	1	2119092-2	BOLT, ADJUSTMENT	139
-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	455888-7	SPACER, CRIMPER	82
-	1	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
-	2	2	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70
-	1	-	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1901681-5	HOLDDOWN, TERMINAL	65
-	2	2	2	2	2168400-8	SHCS, LOW HEAD, RoHS, M4 X 16	64
-	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	1	2063961-1	FEED FINGER	58
-	3	3	3	3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	56
-	2	2	2	2	5018030-2	NUT, HEX, REG, RoHS, M4	55
-	2	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
-	2	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	-	-	1	-	2119792-2	PAWL, EF, AIR	51
-	1	1	1	1	1-1752354-0	STANDOFF,HOLD-DOWN	50
-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
-	7	7	7	7	1-18028-2	WASHER, FLAT, REG M4	33
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	31
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	29
-	1	1	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	2	2	1320906-1	STUD, THREADED	25
-	1	1	1	1	1752371-5	PLATE, STRIP GUIDE	24
-	1	1	1	1	240825-8	PLATE, STRIP HOLD DOWN	23
-	2	2	2	2	2-22281-3	SPRING, COMPRESSION	22
-	1	1	1	1	1752373-1	DRAG	20
-	2	2	2	2	1901259-3	GUIDE, LOWER STRIP	18
-	1	1	1	1	240644-1	PLATE, REAR SHEAR	11
-	-	-	-	-	-	-	10
-	1	1	1	1	690495-3	PLATE, FRONT SHEAR	9
1	1	1	1	1	1-1333217-1	ANVIL, EF .090	8
-	1	1	1	1	4-690474-2	BLADE, SLUG	7
-	1	1	1	1	2-240641-4	SPACER	5
-	1	1	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1	2-1633961-3	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2
1	1	1	1	1	2-456406-3	CRIMPER, WIRE PREMIUM	1
-77-27-25-22-21					PART NO	DESCRIPTION	ITEM NO

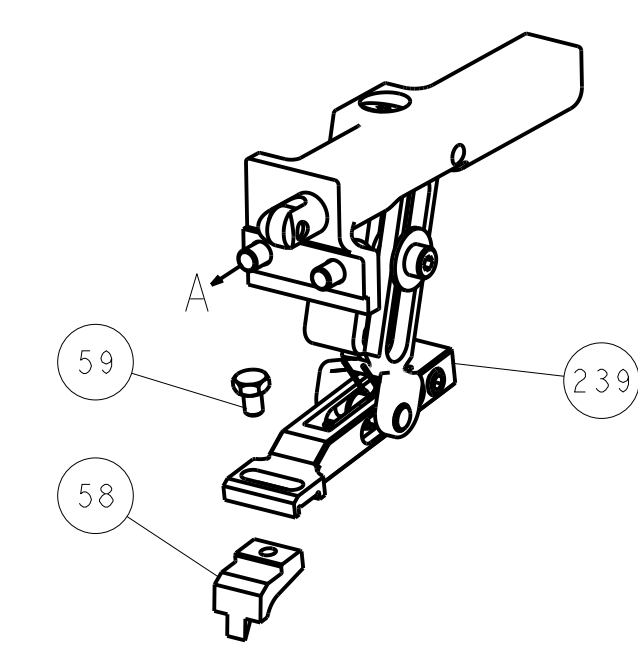
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER SHALL CONTACT THE MANUFACTURING ORGANIZATION FOR THE LATEST REVISIONS.				DWN C.CHEN	10MAY2012	 TE Connectivity Harrisburg, PA 17105-3608			
				CHK S.XI	10MAY2012				
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD J.CRUZ	10MAY2012	NAME Ocean End Feed Applicator			
		0 PLC ±.5		PRODUCT SPEC		SIZE A1			
		1 PLC ±0.13		APPLICATION SPEC					
MATERIAL -		FINISH -		WEIGHT -		CAGE CODE 00779		DRAWING NO C=2150258	
						RESTRICTED TO -			
Customer Accessible Production Drawing				SCALE 1:1		SHEET 3 OF 4			
						REV A			

LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

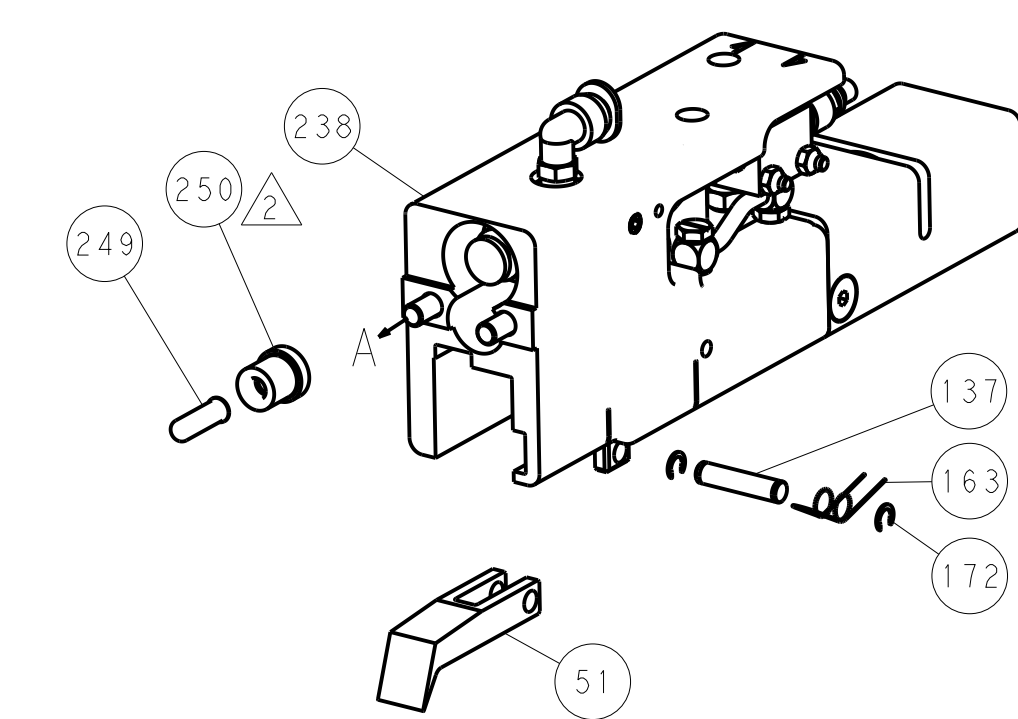
HOLDDOWN SET-UP



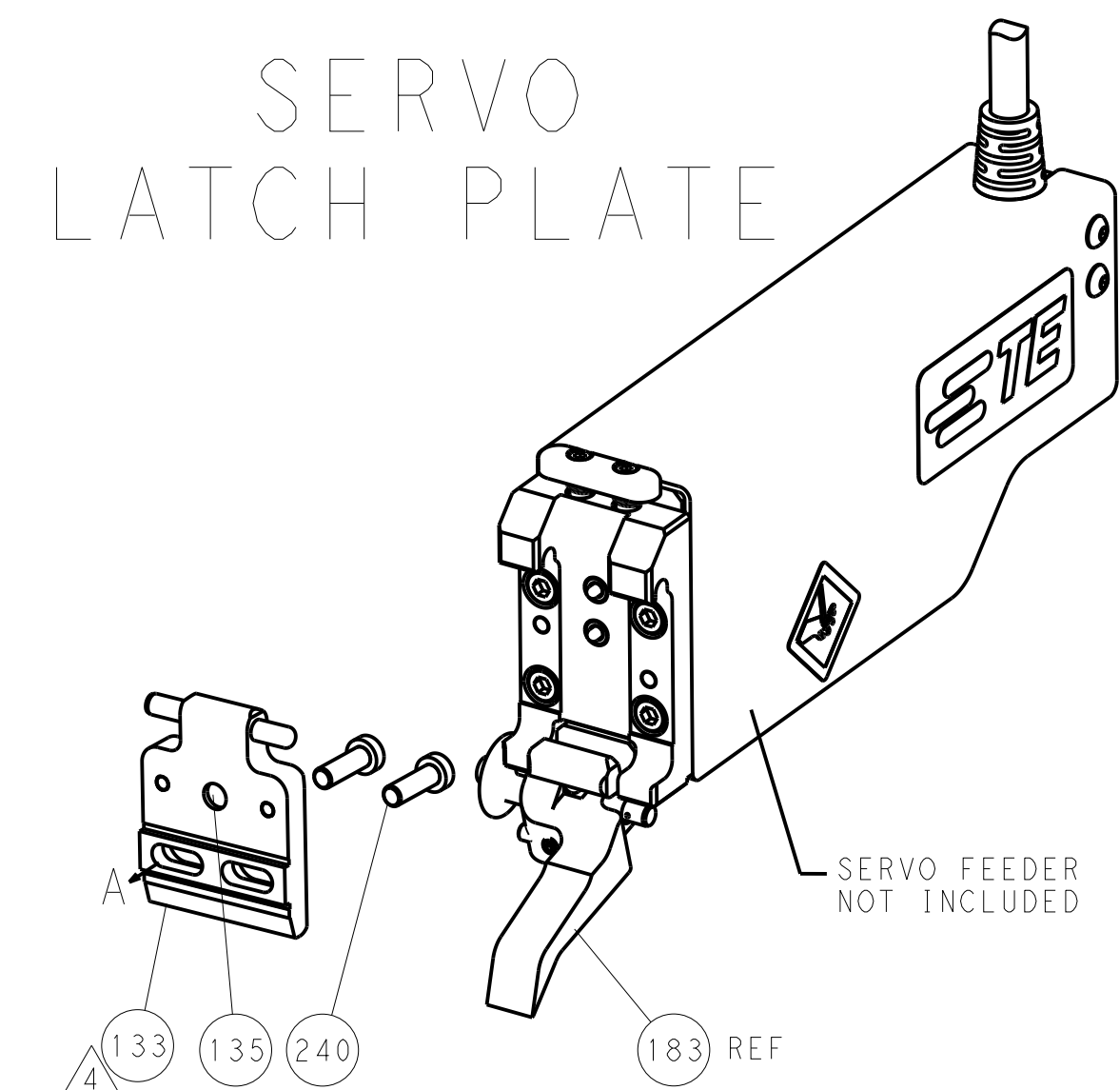
FEED TYPE
MECHANICAL



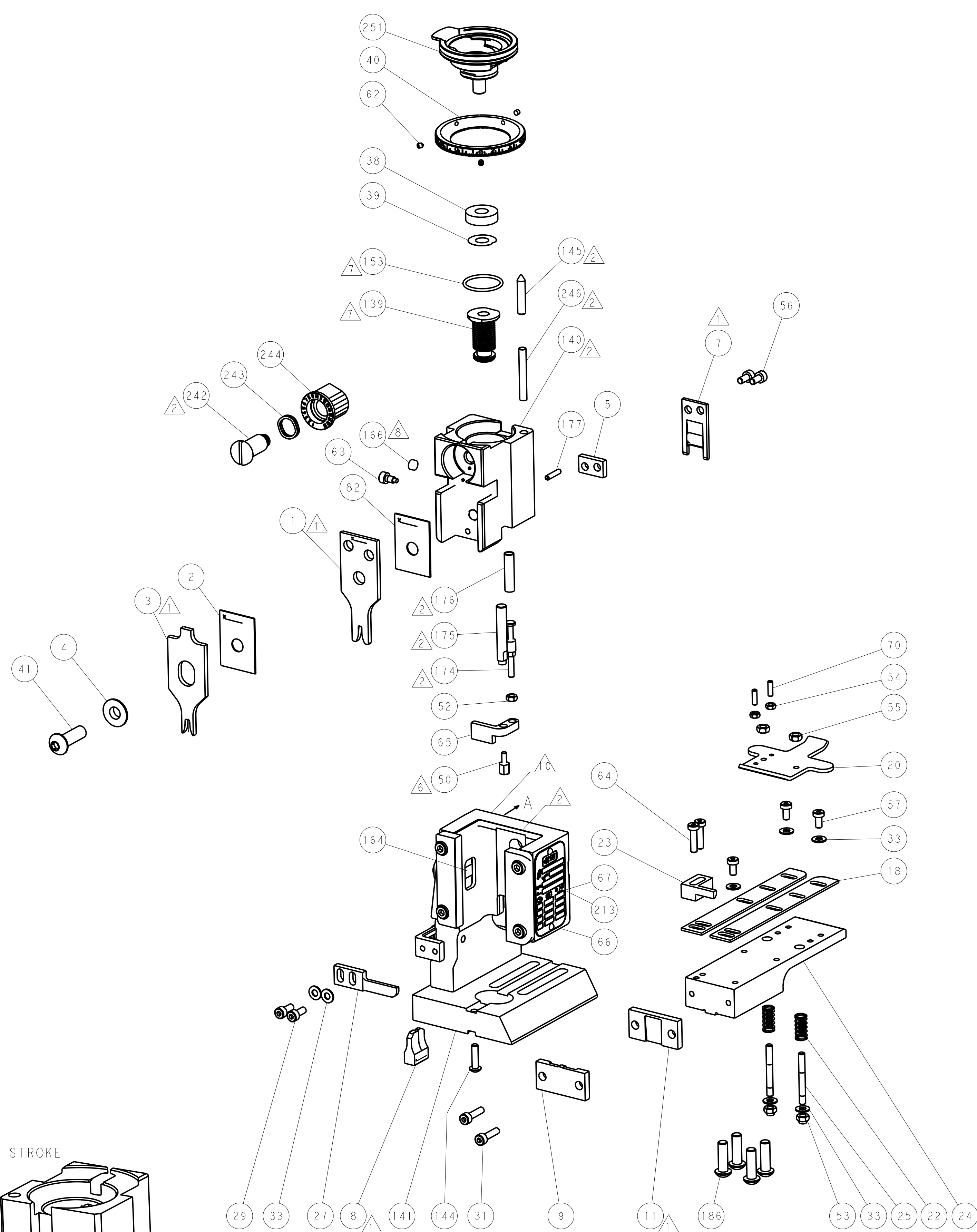
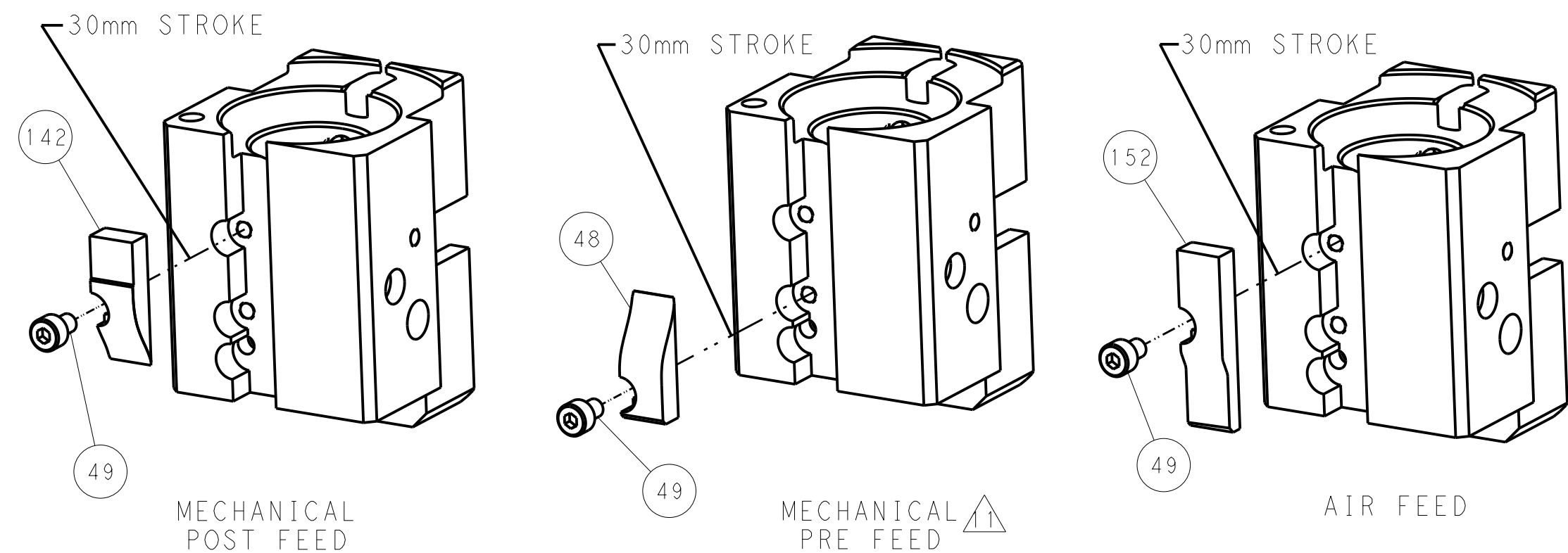
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS



PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.001 ANGLES ±0.001		DWN C. CHEN CHK S. XI APVD J. CRUZ		10MAY2012 10MAY2012 10MAY2012		NAME Ocean End Feed Applicator	
MATERIAL		FINISH		WEIGHT		Customer Accessible Production Drawing		SCALE 1:1	
						SHEET 4 OF 4		REV A1	